

Work Order ID 52824

October 15, 2009 10:37:24 AM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 15/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 29/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: RLDate: 09/10/15 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: M109213

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

SL 09/10/22 (1x)
QC 09 10 26

October 15, 2009 10:37:24 AM



Accept



Setup Start



Stop



Start Date: 15/10/2009 **Start Qty:** 1.00

**Cust Item ID:**

Required Date: 29/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00



BR 09-10-28

①

Memo

0.00

Quality Control

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/30 ~~9~~
ME 09-10-2

Picklist Print

October 15, 2009 10:38:00 AM

Page 1

Work Order ID: 52824

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Start Date: 15/10/2009

Required Date: 29/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH		Manufactured	No			100	Each	17.0000	1.0000			

Rib

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
48101	1	
Main Warehouse		
WA	16	
51250	4	
51872	12	

D2221-5RevH

Manufactured No

100

Each

4.0000

2.0000

Rib

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4	
50026	2	
50583	2	

SY 09/10/21

1x

2x SY 09/10/21

Picklist Print

October 15, 2009 10:38:00 AM

Work Order ID: 52824

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Start Date: 15/10/2009

Required Date: 29/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-7RevH		Manufactured	No			100	Each	6.0000	1.0000			

Rib

✓

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

6

51090

2

51251

4

1x *SY 09/10/21*

D2232-3RevC

Manufactured No

100

Each

11.0000

2.0000



Basket Hinge

✓

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8

50024

2

51870

6

Main Warehouse

WA

3

50986

3

1x *SY 09/10/21*

1x

Picklist Print

October 15, 2009 10:38:00 AM

Work Order ID: 52824



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 15/10/2009

Required Date: 29/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2235-1RevB1		Manufactured	No			100	Each	22.0000	2.0000			
Basket Rib												

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	9	
51438	9	
Main Warehouse		
WA	13	
50565	3	
51871	10	

2x SY 09/10/21

D2581RevA1

Manufactured No

100

Each

76.0000

2.0000



Mounting Bracket

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	13	
46086	2	
48428	1	
51120	10	
Main Warehouse		
WA	63	
50872	14	
51745	49	

2x SY 09/10/21

Picklist Print

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Work Order ID: 52824



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 15/10/2009

Required Date: 29/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3442-1RevA		Manufactured	No			100	Each	20.0000	2.0000			

Shim



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

2

46767

1

50023

1

1x

Main Warehouse

WA

18

50951

18

1x

09/10/21

D3825-041RevA

Manufactured

No

100

Each

10.0000

2.0000



Rib Assembly (Basket End)



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

6

51869

6

Main Warehouse

WA

4

51171

4

2x

09/10/21

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Shop Packet Print

Page 4

Picklist Print

October 15, 2009 10:38:00 AM

Work Order ID: 52824

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Start Date: 15/10/2009

Required Date: 29/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3826-041RevB		Manufactured	No			100	Each	10.0000	2.0000			
												

Rib / Gusset Assembly

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
51340	6	
Main Warehouse		
WA	4	
51088	4	

D3827-041RevA

Manufactured

No

100

Each

7.0000

1.0000



Rib Assembly (Inboard)

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
51339	6	
Main Warehouse		
WA	1	
51091	1	

2x *SY* 09/10/21

1x *SY* 09/10/21

Picklist Print

October 15, 2009 10:38:00 AM

Work Order ID: 52824

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Start Date: 15/10/2009

Required Date: 29/10/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3832-1RevA		Manufactured	No			100	Each	7.0000	1.0000			

Mesh (Base)

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
46306	1	
46774	1	
Main Warehouse		
WA	5	
50942	2	
51863	3	

1x 09/10/22

D3833-1RevA

Manufactured No

100

Each

12.0000

2.0000

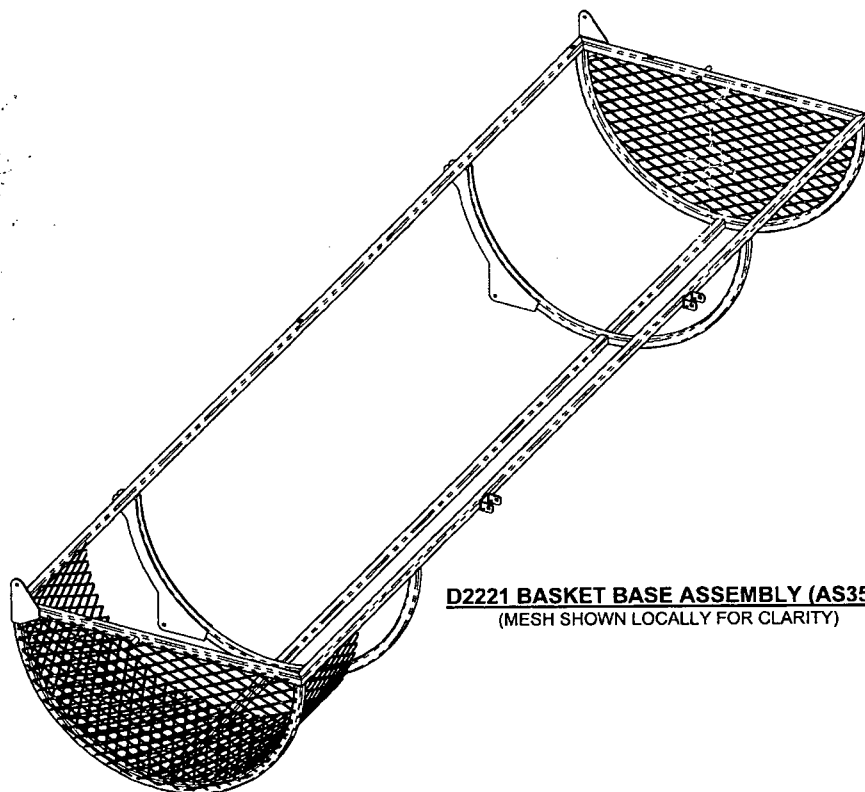


Mesh (Base End Face)

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
51304	8	
Main Warehouse		
WA	4	
50025	2	
51134	2	

2x 09/10/21



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52824
BL 09-10-15

NOTES:
MATERIAL: N/A
FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 42.00 lbs APPROX
MASK ALL HOLES PRIOR TO POWDER COATING

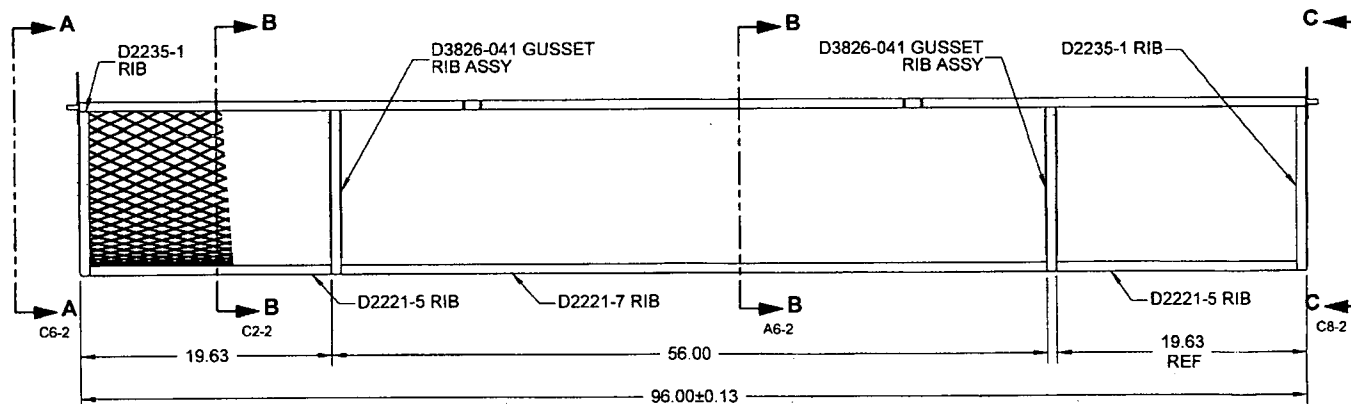
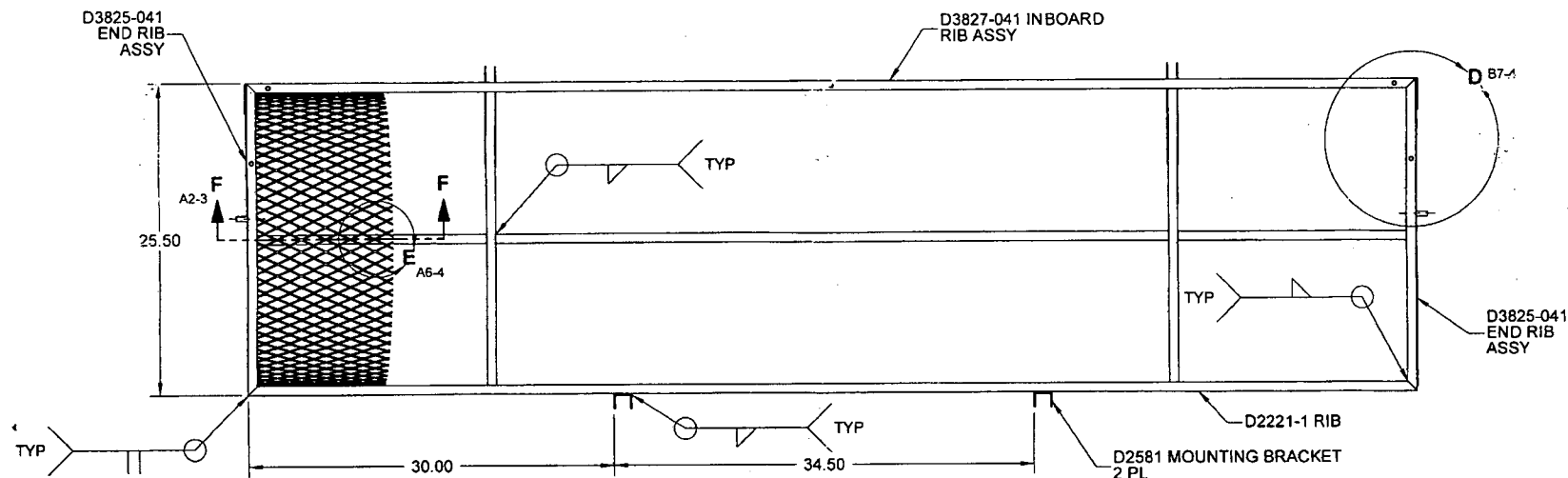
ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
08/11/15

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 98.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2, SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	BW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JLS	DRAWING NO.	REV.
MFG. APPR.	JLS	D2221	SHEET 1 OF 5
APPROVED	JLS	TITLE	SCALE
DE APPR.	JLS	BASKET BASE ASSEMBLY (350) N	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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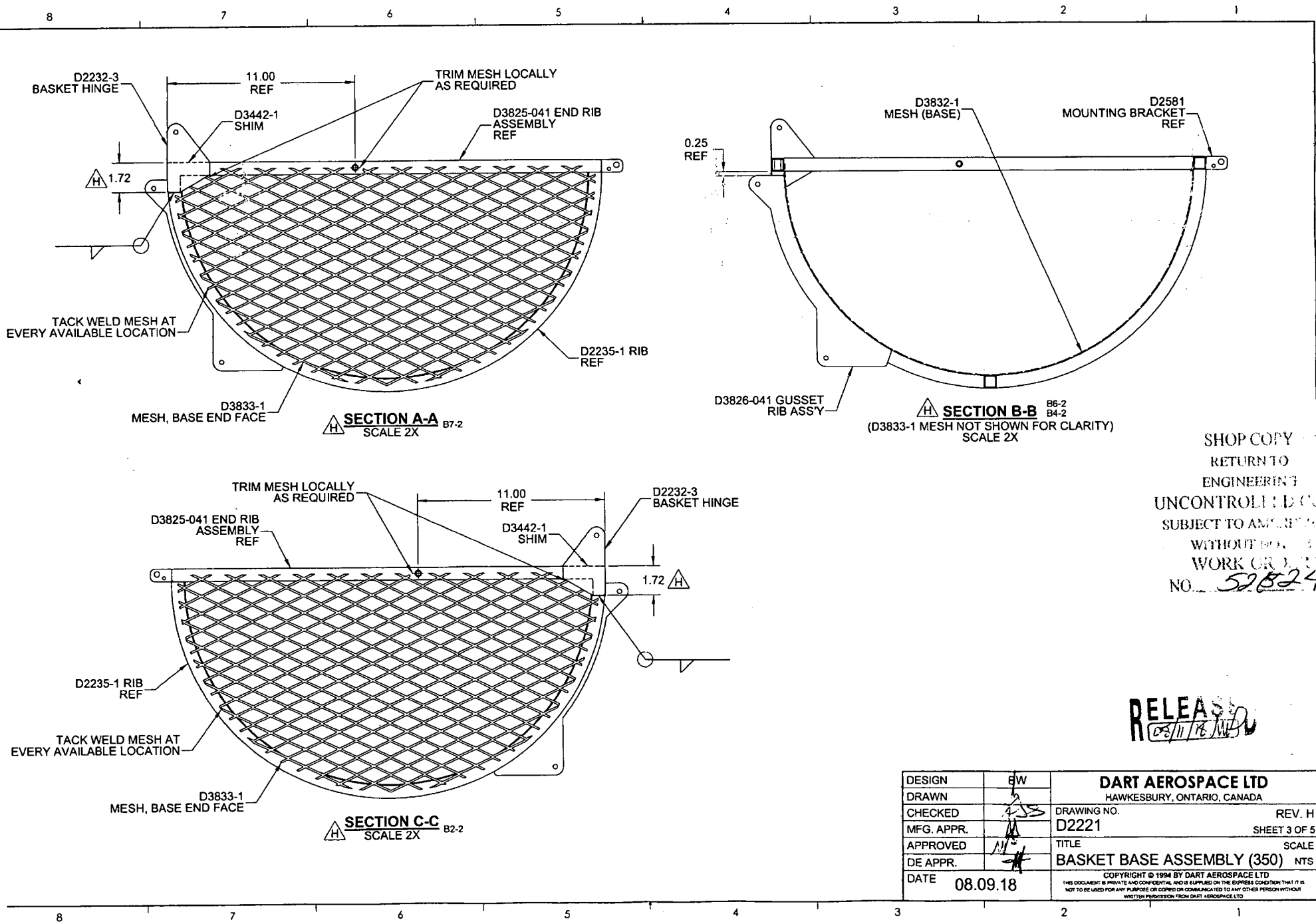
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D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



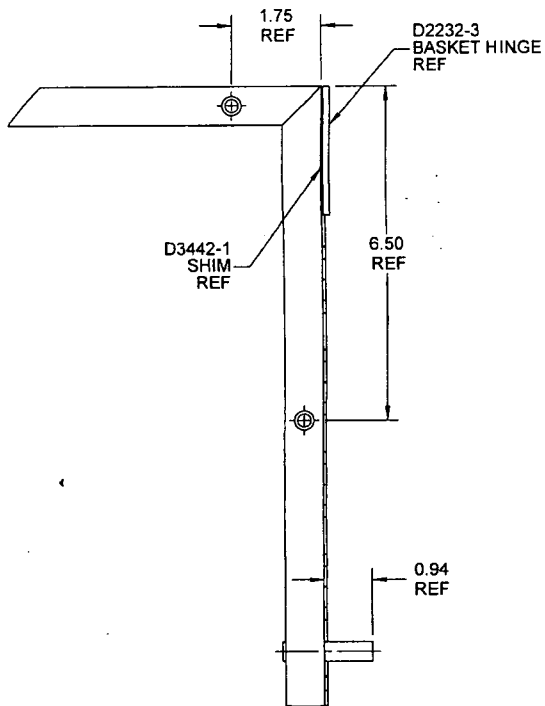
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RELEASE
03/11/16

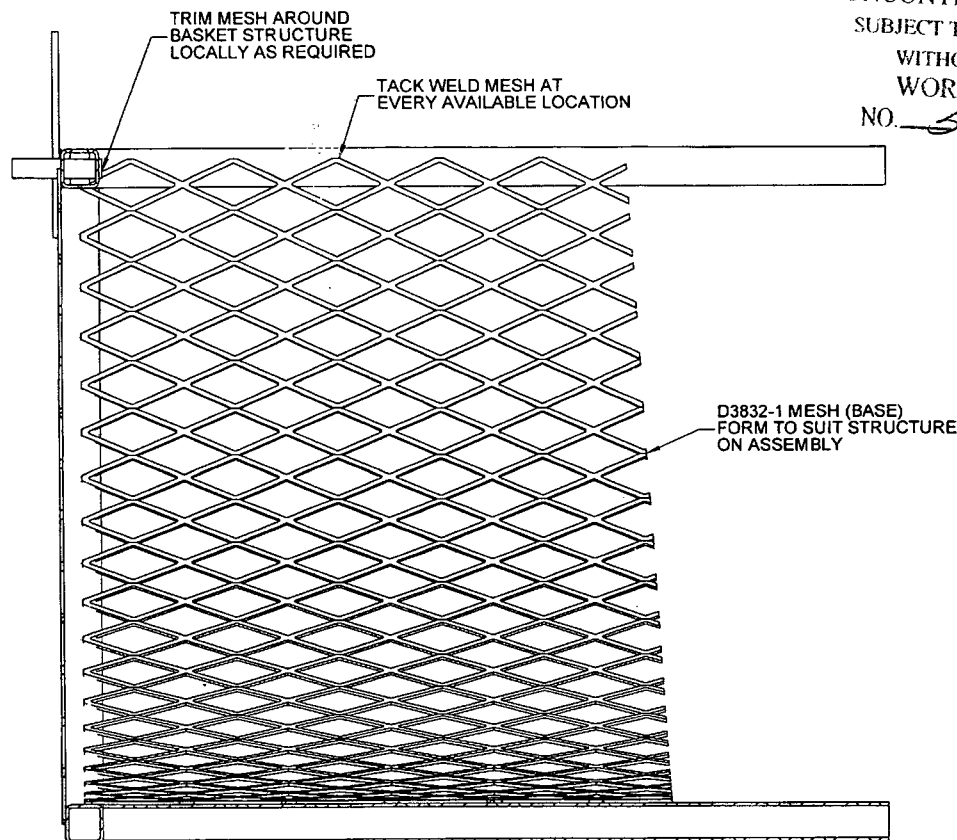
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DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	435	DRAWING NO.	REV. H
MFG. APPR.	A	D2221	SHEET 3 OF 5
APPROVED	M	TITLE	SCALE
DE APPR.	H	BASKET BASE ASSEMBLY (350) NTS	
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8 7 6 5 4 3 2 1

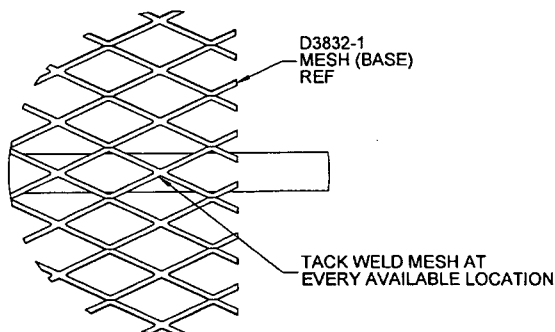
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WORK ORDER
NO. 52824



DETAIL D
SCALE 4X D2-2



SECTION F-F
SCALE 4X D7-2



DETAIL E
SCALE 4X C6-2

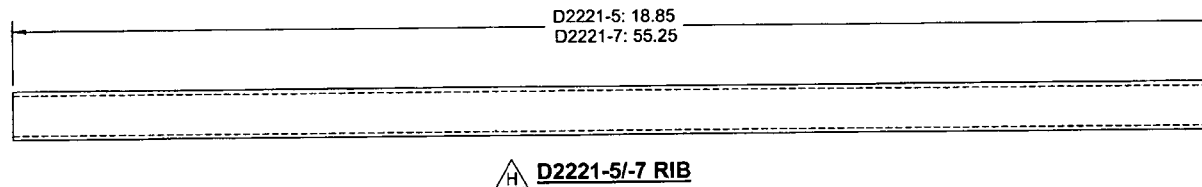
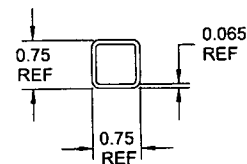
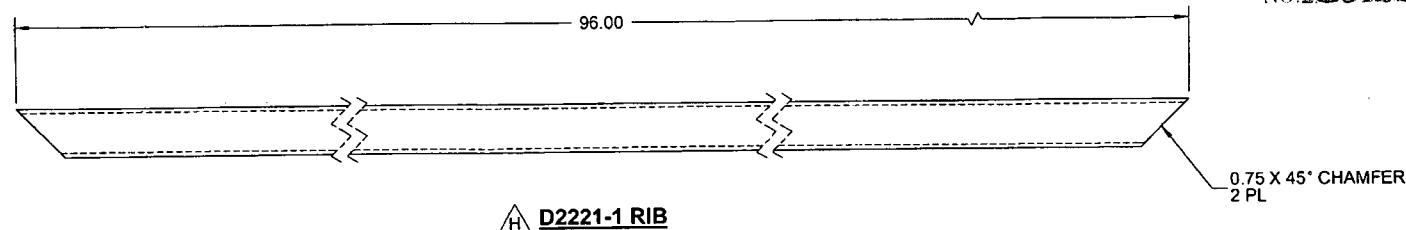
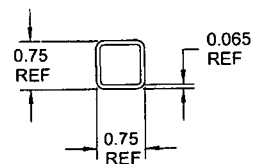
RELEASED
02/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	10/8	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED	21/10	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

Sheet 5

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WITHOUT NOTICE
WORK ORDER NO. 52824



RELEASED
08/11/18

NOTES:
MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
FINISH: NONE
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ABS	DRAWING NO. D2221	REV. H
MFG. APPR.	MD	SHEET 5 OF 5	
APPROVED	W	TITLE BASKET BASE ASSEMBLY (350) SCALE NTS	
DE APPR.	CH	DATE 08.09.18	
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